



Dart Aerospace Ltd.
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RBE350A93-3312-03

Job Sheet 197360



Part No: RBE350A93-3312-03

Job Qty: 6 pcs

10 MLC

Part Name: Tail Rotor Hub Bushing Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3312-03 Rev G IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev. G DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	6 pcs	9/2/19		0.00	0.60	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	6 pcs	9/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	6 pcs	9/2/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S218873



Part: RBE350A93-3312-03

Job No: 197360

Serial No/Batch: S218873

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 10/01/19

Plex 7/5/19 7:48 AM Dart.lajeunesse.marie

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	6 pcs	9/2/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS

21

9-89

OCT 03 2019

Part Op 100 - (Small Fab) - Assemble as per DWG sheet 1.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90685A110	Hex Nut M12 X 1.75mm	6 Ea (1 ea)	100-Small Fab - 1	5089114
95327A708	Hex Head Screw M12 X 1.75mm x 100mm LG.	6 Ea (1 ea)	100-Small Fab - 1	5198266
RBE350A93-3312-03-1	Receiver	6 pcs (1 ea)	100-Small Fab - 1	5153200
RBE350A93-3312-03-3	Remover / Installer	6 pcs (1 ea)	100-Small Fab - 1	5099930
RBE350A93-3312-03-5	Seat	6 pcs (1 ea)	100-Small Fab - 1	5205863
RBE350A93-3312-03-7	Washer	6 pcs (1 ea)	100-Small Fab - 1	5206018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90685A110	6	21	0
	95327A708	6	12	0
	RBE350A93-3312-03-1	6	11	0
	RBE350A93-3312-03-3	6	3	0
	RBE350A93-3312-03-5	6	2	0
	RBE350A93-3312-03-7	6	2	0

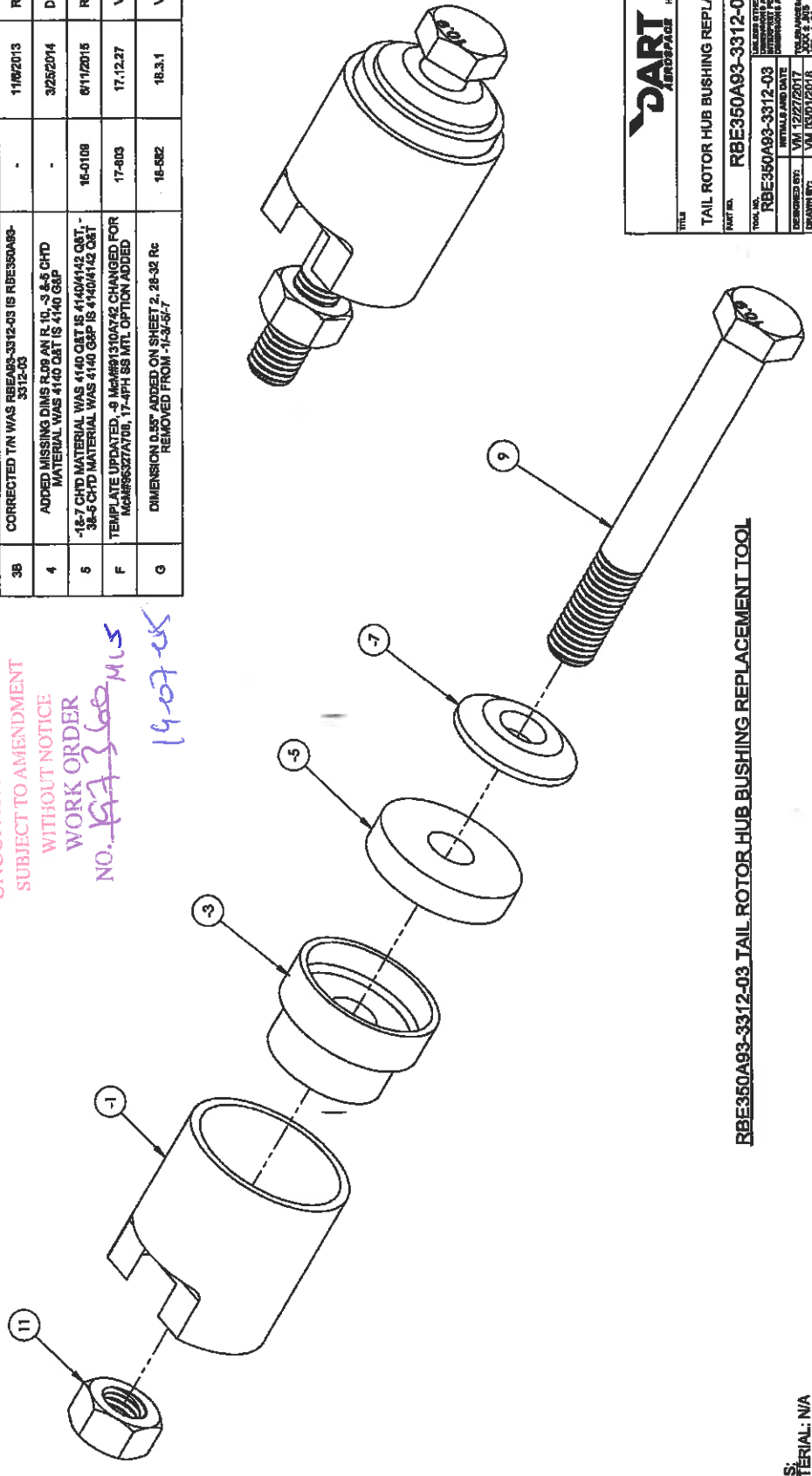
Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	TITLE
-1	1	RBE350A93-3312-03-1	RECEIVER
-3	1	RBE350A93-3312-03-3	REMOVER / INSTALLER
-5	1	RBE350A93-3312-03-5	SEAT
-7	1	RBE350A93-3312-03-7	WASHER
9	1	McMaster925327A708	HEX HEAD SCREW M12 x 1.75 x 100mm LG.
11	1	McMaster925327A710	HEX NUT M12 x 1.75

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~147360~~ *147360* *MCS*
1407-05

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	-01 ADDED S/N, "MADE IN USA"	-	4/29/2009	RJC	-
2	CHD ALL HOLES FROM 12.2mm TO 12mm FOR BETTER TOOL ALIGNMENT. CHANGES MADE TO MATCH CURRENT HELL-PRODUCTS TOOLS AND MORE OPEN TOLERANCES. -01 CHD DEPTH FROM .384 TO 1.06, ADDED R12 FOR LOOSER TOLERANCE. -03 CHD DIM FROM DIA 1.480 TO 1.467, FROM .388 TO .34, -04 CHD DIA 1.467 TO DIA 1.480 IS 1.467	-	9/30/2009	WP	RW
3	-01 CHD DIM WAS DIA 1.500 IS DIA 1.500 +0/-0.003	-	12/16/2010	RJC	RW
3A	-03 ADDED MISSING DIM .325	-	9/22/2011	RJC	GE
3B	CORRECTED T/N WAS REBAR-3312-03 IS RBE350A93-3312-03	-	11/02/2013	RJC	RW
4	ADDED MISSING DIMS R.09 AN R.10, -3 & -5 CHD MATERIAL WAS 4140 Q&T IS 4140/4142 Q&T	-	3/25/2014	DPD	GE
5	-1& -7 CHD MATERIAL WAS 4140 Q&T IS 4140/4142 Q&T, -3& -5 CHD MATERIAL WAS 4140 Q&P IS 4140/4142 Q&T	16-0108	6/11/2015	RJC	JAG
F	TEMPLATE UPDATED, -9 McMASTER 1310A142 CHANGED FOR HOLES 63527A708, 17-4PH SS MTL OPTION ADDED	17-803	17.12.27	VM	ML
G	DIMENSION Q&T ADDED ON SHEET 2, 28-32 Rc REMOVED FROM -14-01-01-7	16-582	18.3.1	VM	ML



RBE350A93-3312-03 TAIL ROTOR HUB BUSHING REPLACEMENT TOOL

DART AEROSPACE Hemelock, Ontario, Canada	
TITLE TAIL ROTOR HUB BUSHING REPLACEMENT TOOL	
PART NO. RBE350A93-3312-03	REV G
DATE 12/16/2010	
DESIGNED BY VM 12/27/07	
CHECKED BY VM 03/01/2015	
APPROVED BY JFC 03/01/2015	
SCALE N/A	
SHEET 1 OF 1	
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- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐				Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				MRB (QS1042) ☐ ☐ ☐ ☐ ☐			
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)											
Description Work Order Deviation						Disposition											
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐						FAULT CATEGORY											
						Pressure/Forced Bending ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐		Contamination Misaligned/off center ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐		Power Loss/Surge ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐		Positioned Wrong ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐					
						Other/Details: _____											
						Completed By _____						Lead hand / Supervisor _____					
QC / QA Coordinator _____																	